



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D4463-041
Job Sheet 174294



Part No: D4463-041

Job Qty: 2 ea

Part Name: Tank Top Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/13/18

Job Tracking No:

Due Date: 4/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV D SHEETS 1,2 IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B 12.04.25 AS PER
DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/20/18	4/20/18	0.00	0.00	Start Up Waterjet		SC 18/03/19
100	Waterjet	2 pcs	4/20/18	4/20/18	0.01	0.79	Waterjet1		SC 18/03/19
110	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC2 Waterjet-3		SC 18/03/19
120	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC8-4		38
130	Small Fab	2 pcs	4/20/18	4/20/18	0.00	0.75	Small Fab-6		DAS
140	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC5		38
150	HandFinish	2 pcs	4/20/18	4/20/18	0.00	0.32	HandFinish1		SA 18-04-04
160	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC7-3		DAS
170	Small Fab	2 pcs	4/20/18	4/20/18	0.00	0.75	Small Fab-6		38
180	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC5		38
190	Packaging	2 pcs	4/20/18	4/20/18	0.00	0.00	Packaging3-2		DG 2018-04-05
200	QC21-SA	2 Ea	4/20/18	4/20/18	0.00	0.00	QC21		DAS 21 9-50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	7.7280 sf (3.864 ea)	90-Start up Operation	
MS20426AD3-4	Rivet	96 Ea (48 ea)	170-Small Fab	FM136444-2
NAS1473R3	Anchor Nut	48 Ea (24 ea)	170-Small Fab	5000571 25x FM13589512x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	8	216	0
170-Small Fab	MS20426AD3-4	96	4,084	0
	NAS1473R3	48	82	0

Part Specifications

Specifications could not be found.



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Container No: S052763



Part: D4463-041

Job No: 174294

Serial No/Batch: S052763

Revision:

Inspector:

Date: 03/19/18

DART AEROSPACE LTD		Work Order:	174294
Description: Tank Top		Part Number:	D4463-1
Inspection Dwg: D4463	Rev: D	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0,100	1		VDC-01	
Ø0.206	+0.005/-0.001	Ø0,207	1		Tape	
Ø1.00	+0.012/-0.001	Ø1,00	1			
1.15	+/-0.030	1,16	1			
1.85	+/-0.030	1,86	1			
2.20	+/-0.030	2,21	1			
2.30	+/-0.030	2,30	1			
5.29	+/-0.030	5,30	1			
8.30	+/-0.030	8,30	1			
8.93	+/-0.030	8,94	1			
8.98	+/-0.030	8,98	1			
9.31	+/-0.030	9,30	1			
10.42	+/-0.030	10,42	1			
11.26	+/-0.030	11,27	1			
1.61	+/-0.030	1,60	1			
1.68	+/-0.030	1,69	1			
1.82	+/-0.030	1,83	1			
3.41	+/-0.030	3,40	1			
3.79	+/-0.030	3,80	1			
6.43	+/-0.030	6,44	1			
7.36	+/-0.030	7,35	1			
7.80	+/-0.030	7,80	1			
10.75	+/-0.030	10,75	1			
11.38	+/-0.030	11,39	1			
11.80	+/-0.030	11,80	1			
13.27	+/-0.030	13,28	1			
1.15	+/-0.030	1,15	1			
3.00	+/-0.030	3,00	1			
3.26	+/-0.030	3,25	1			
7.00	+/-0.030	7,00	1			
10.74	+/-0.030	10,75	1			
11.00	+/-0.030	11,00	1			
11.63	+/-0.030	11,64	1			
15.29	+/-0.030	15,30	1			
15.48	+/-0.030	15,49	1			
19.48	+/-0.030	19,49	1			
23.48	+/-0.030	23,49	1			
23.67	+/-0.030	23,66	1			
24.11	+/-0.030	24,10	1			
27.46	+/-0.030	27,45	1			

